

Work Order ID 81801

Blue
81801

Page 1

March-19-12 1:33:50 PM

Item ID: D2932-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle LH Out, 206
 Start Date: 19/03/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 18/05/2012 *u* Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: *ML3* Date: *12/03/19* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2932	Rev C								

100 HAAS CNC VERTICAL MACHINING #1 0.00
100
 HAAS 1 *FK 12/04/25* *8 d*
 HAAS CNC vertical machine #1 *SL 12-04-26*

Memo
 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110 CONVENTIONAL MILLING MACHINE 0.00
110
 Mill Conv *FK 12/04/25* *8 d*
 Conventional Milling Machine *SL 12-04-26*

Memo
 Machine Keyway and inspect per attached dimension sheet

120 QC1- Inspect dimensions to dimension sheet 0.00
120
 QC *FK 12/04/25* *8 d*
 Quality Control *SL 12-04-26*

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
155	Spray Painting per QSI005 4.2	0.00							
155									
SprayPaint	Memo	0.00							
Spray Painting	PRIME B <u>117319</u> DELFLEET BLUE B <u>121149</u> CLEAR DELFLEET B <u>118093</u>								

4 12-4-26

AP 12-5-1 8

W/O:		WORK ORDER CHANGES					
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Item ID: D2932-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle LH Out, 206

Start Date: 19/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

165

QC14- Inspect Spray Paint

0.00

165

QC

Memo

0.00

Quality Control

ml 12.05.03 (8)

170

Identify as per dwg & Stock Location: 421

0.00

170

Packaging

Memo

0.00

Packaging

8 12/05/04

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/05/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-19-12 1:33:53 PM

Page 1

Work Order ID: 81801

81801

Parent Item: D2932-1

D2932-1

Parent Item Name: Saddle LH Out, 206

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B00.06.26New DWG rev, (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	54.0000	1	8			

D6101-003

Saddle Billet, 7075

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	26	
73775	2	
73780	7	
78599	10	
MAT041	34	
79587	4	
80765	30	
MAT042	-7	
MAT044	1	
73769	1	

81924

8

FK 12/04/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	81801
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.114	.115	.115	.124		
B	0.100	0.140		.114	.115	.115	.124		
C	0.100	0.140		.110	.114	.115	.119		
D	0.210	0.230		.223	.223	.223	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.236	.236	.236	.237		
N	0.100	0.140		.121	.121	.122	.120		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.494	2.494	2.490		
S	0.240	0.270		.253	.253	.252	.253		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.135	1.136	1.136		
Y	1.565	1.585		1.574	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	FK.
Date:	12/04/25 / 12-04-26

Audited by:	RF
Date:	12-4-26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD	Work Order: 81801
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

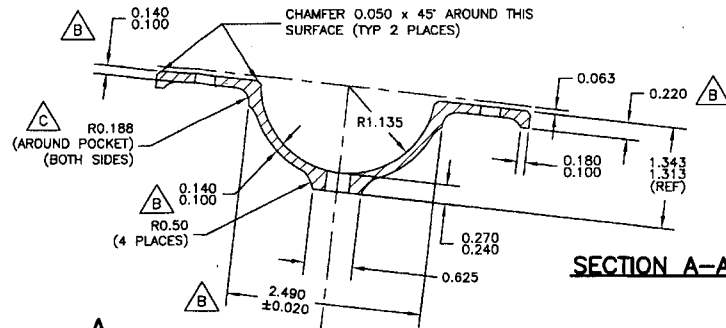
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.125	.124	.123		
B	0.100	0.140		.123	.125	.124	.123		
C	0.100	0.140		.119	.120	.120	.121		
D	0.210	0.230		.220	.220	.221	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.234	.234	.234	.234		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.551	.550	.550	.551		
P	0.490	0.510		.500	.501	.500	.503		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.252	.251	.252	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.636	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
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Y	1.565	1.585		1.572	1.573	1.574	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u> JL </u>
Date: <u>12-04-26</u>

Audited by: <u> RF </u>
Date: <u>12-4-26</u>

Rev	Date	Change	Revised by	Approved
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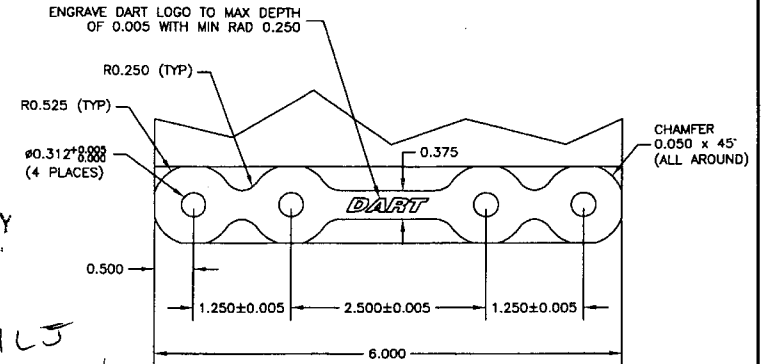


SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81801 MLJ

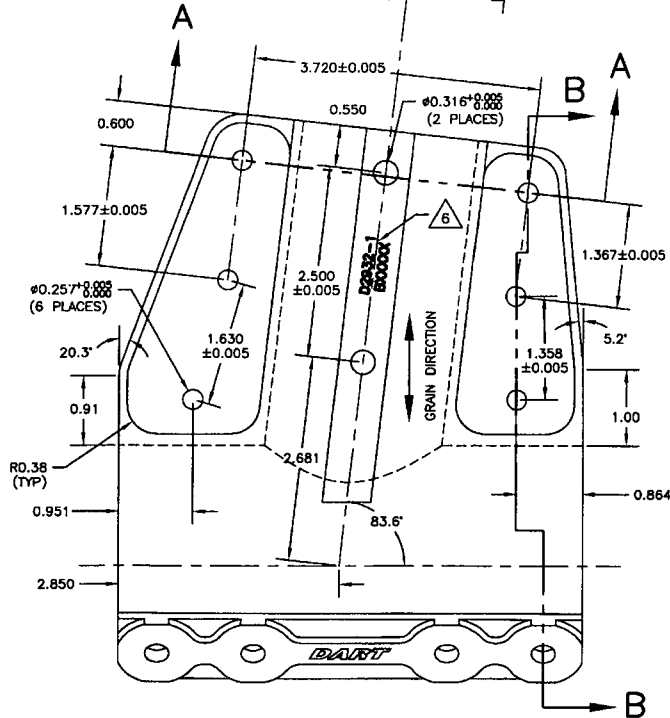
12/03/19



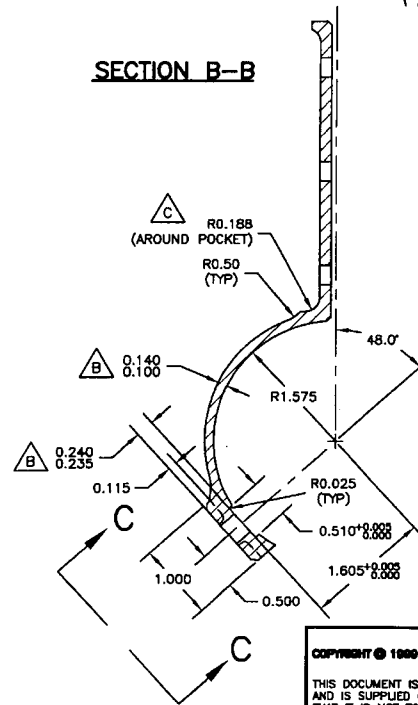
VIEW C-C

D2932-1 LH SADDLE (SHOWN)

D2932-2 RH SADDLE (OPPOSITE)



SECTION B-B



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2932
DATE		TITLE SADDLE OUTSIDE
06.11.09		REV. C SHEET 1 OF 1 SCALE 2:3

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

RELEASED
07-02-12

W/O:		WORK ORDER CHANGES					
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